

IN THE CLAIMS

Claims 1-36 were previously cancelled. Claims 37-42, 45-48, 50-53, 58, 59 and 64-66 are currently amended. Claims 67, 68 and 70 are currently cancelled. Claims 43, 44, 49, 54-57, 60-63 and 69 are carried forward, all as follows:

Claims 1-36 (Cancelled)

37. (Currently Amended) A method for storing unprepared and prepared rolls of material in a depot for use in roll changer in [[by]] a web-fed rotary printing ~~material processing~~ machine including:

providing a material flow system for said web-fed rotary printing machine;

providing an implemented logic device in said material flow system;

providing said material flow system with production-relevant ~~information regarding one of a prognosis of use~~ data for a planned pending production run of said web-fed rotary printing machine period to be examined by ~~said material processing machine and use data derived by prognosis~~;

~~determining an actual stock on hand in said depot; and~~

~~determining, in a first partial process of said material flow system, a production-oriented storage strategy using said production-relevant data for said planned production run; obtained by prognosis and said actual stock on hand.~~

determining, in a second partial process of said material flow system, information on an occupancy in said depot of said unprepared and prepared rolls of material; and

using said production-oriented storage strategy and repositioning said unprepared and prepared rolls of material in occupancy in said depot for optimized delivery of said prepared rolls of material to said roll changers of said web-fed rotary printing machine from said depot and for preparing previously unprepared rolls of material for their delivery to said roll changers of said web-fed rotary printer machine in accordance with said production-oriented storage strategy.

38. (Currently Amended) The method of claim 37 further including considering criteria for a degree of use of storage in said depot in said planned printing production run period to be examined.

39. (Currently Amended) The method of claim 37 further including considering criteria for an intended length of storage time of fresh rolls of said material during said planned production run period to be examined.

40. (Currently Amended) The method of claim 39 further including determining said storage strategy including considering said criteria for an intended length of storage time of fresh rolls during said planned production run period to be examined.

41. (Currently Amended) The method of claim 37 further including considering a period of an effectiveness of a glue preparation of said rolls of material during said planned production run using said implemented logic device period.

42. (Currently Amended) The method of claim 37 further including providing a first shelf block remote from said web-fed rotary printing material processing machine in said depot, providing a second shelf block adjacent said web-fed rotary printing material processing machine and providing an inner shelf block located between said first shelf block and said second shelf block.

43. (Previously Presented) The method of claim 42 including, in a low storage application utilizing said first shelf block for storage of only unprepared rolls, utilizing said second shelf block for storage of prepared rolls and maintaining said inner shelf block empty except for passage of said rolls.

44. (Previously Presented) The method of claim 42 including, in one of a normal storage and a high storage application, utilizing said first shelf block for storage of only unprepared rolls, utilizing said second shelf block for storage of only prepared rolls and utilizing said inner shelf block as a buffer for unprepared rolls and for prepared rolls.

45. (Currently Amended) The method of claim 37 further including considering criteria of a type of said rolls of material needed in said planned production run period to be examined and further including differentiating in said type of said rolls of material needed, between many small planned production runs productions and fewer large planned production runs productions.

46. (Currently Amended) The method of claim 45 further including reserving sufficient space in said depot for the return of used rolls to said depot when said planned production run period includes said many small planned production runs productions.

47. (Currently Amended) The method of claim 45 further including storing said prepared rolls in a travel optimized manner when said production period includes said fewer large planned production runs productions.

48. (Currently Amended) The method of claim 37 further including, ~~in a second partial process, checking an occupancy of said depot and positioning of said prepared and unprepared rolls in said depot in a manner optimized for production, and determining said [[a]] strategy for repositioning said prepared and unprepared rolls in said depot using criteria for a degree of storage use to be expected during said planned production run period under examination.~~

49. (Previously Presented) The method of claim 48 further including providing said material flow system with information regarding an actual stock of said rolls of material on hand.

50. (Currently Amended) The method of claim 49 further including determining a strategy for a production-oriented repositioning in said depot using criteria for an extent of depot occupancy during said planned production run period to be examined.

51. (Currently Amended) The method of claim 50 further including providing roll changers in said web-fed rotary printing material processing machine and considering an extent of occupancy of said depot whenever, in low occupancy, storage of said prepared rolls is taking place in a path-optimized manner with respect to one of said roll changers to be served severed and wherein, in high occupancy, storage of said prepared rolls is taking place chaotically in said depot acting together with active ones of said roll changers.

52. (Currently Amended) The method of claim 42 further including providing a first serving element remote from said web-fed rotary printing material processing machine and locating said first serving element between said first and third shelf blocks, and further including providing a second serving element adjacent said web-fed rotary printing material processing machine and locating said second serving element between said second and said inner shelf blocks.

53. (Currently Amended) The method of claim 52 further including locating ones of said prepared rolls, which will be required for use within a short time, in one of said second and said inner shelf blocks.

54. (Previously Presented) The method of claim 52 further including redepotting unprepared ones of said rolls of material for preparation of said rolls of materials in an access area of said second serving element.

55. (Previously Presented) The method of claim 37 further including providing a roll preparation circuit in said depot and processing said unprepared rolls in said roll preparation circuit.

56. (Previously Presented) The method of claim 54 further including providing a roll preparation circuit in said depot and removing unprepared rolls from one of said first shelf block and said inner shelf block, using one of said serving elements, and supplying said unprepared rolls to said roll preparation circuit.

57. (Previously Presented) The method of claim 56 further including placing said rolls of material, after passage through said roll preparation circuit, into intermediate storage in said inner shelf block.

58. (Currently Amended) The method of claim 42 further including storing said rolls of material in one of said first shelf block and said inner shelf block as a result of a storage demand ~~distance~~ from said [[a]] first partial process.

59. (Currently Amended) The method of claim 42 further including delivering a prepared roll of said material from one of said first storage block and said inner storage block to a storage space in said second shelf block as a result of a storage demand from said first [[a]] partial process.

60. (Previously Presented) The method of claim 50 further including categorizing a degree of occupancy of said depot below 40% as low occupancy.

61. (Previously Presented) The method of claim 50 further including categorizing a degree of occupancy of said depot above 70% as high occupancy.

62. (Previously Presented) The method of claim 38 further including storing said criteria in exact and changeable definition.

63. (Previously Presented) The method of claim 38 further including storing said criteria in a form of a changeable term of a linguistic variable of a fuzzy logic control.

64. (Currently Amended) The method of claim 37 further including providing one of a computing unit and a data processing unit in said material flow system and forwarding one of production-relevant data and use data regarding planned production from ~~of-a~~ production planning system to said one of said computing unit and said data processing unit.

65. (Currently Amended) The method of claim 64 further including determining said [[a]] storage strategy and a deposit request for said unprepared rolls of material using said one of said computing unit and said data processing unit using said production-relevant prognostic-use data for said planned a pending production run period and information regarding an actual stock of said rolls of material, and further including fixing a time for a production preparation of said rolls of material in a preparation circuit using said implemented logic a logical device in said material flow system and considering a limited shelf life of a glue preparation and a planned length of said [[a]] production run time.

66. (Currently Amended) The method of claim 64 further including directing a partial signal requesting rolls of material to said material flow system, registering said partial signal in said one of said computing unit and said data processing unit and determining said partial signal using existing data regarding depot occupancy for availability in said depot and ordering removal of said prepared and unprepared rolls of material from said depot in response to said request directly through said material flow system.

67. Cancelled.

68. Cancelled.

69. (Previously Presented) The method of claim 37 further including providing storage spaces in said depot for storing said unprepared and prepared rolls of material, continuously checking an occupancy of said depot in respect to planned requirements using a predetermined criteria and positioning said unprepared and prepared rolls of material in said storage spaces in a production-optimized manner.

70. Cancelled.